



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3883-1
Job Sheet 165400



Part No: D3883-1

Job Qty: 7 ea

Part Name: Saddle, Outboard LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D3883-1 Saddle, Outboard LH	DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD VERF:JLM		0.000	
D6101-015 Saddle Billet	DWG REV B IPP RevA: New issue DD verified by:EC		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	7 Ea	10/28/17	0.00	0.00	Start up container	SBI
100	CNC Vertical Machining	7 pcs	10/30/17	0.86	14.58	HAAS 1	SBL
105	Mill Conv	7 pcs	10/30/17	0.00	0.00	Mill Conv 1	
110	QC	7 pcs	10/30/17	0.00	0.00	QC2	
120	QC	7 pcs	10/30/17	0.00	0.00	QC8	B 17-10-24
130	HandFinish	7 pcs	10/30/17	0.00	0.51	HandFinish1	JSL 2017/10/24
140	Powdercoat	7 pcs	10/31/17	0.00	0.27	Powdercoat1	DAS
150	QC	7 pcs	10/31/17	0.00	0.00	QC3	38
160	Packaging	7 pcs	10/31/17	0.00	0.00	Packaging3	9-89
170	QC21-SA	7 Ea	10/31/17	0.00	0.00	QC21	HLJ 17-10-24

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets
Descriptions: 3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets MILL AS PER DWG AND FOLIO FA815

105 - MILL KEYWAY AS PER DWG

140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)*** **DO NOT MASK INSIDE FLANGE SURFACE***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-015	7	0	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S001177

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle, Outboard LH

PART NO: D3883-1
Revision:
Operation: QC21-SA
Quantity: 7
Change No:

Mfg Date: 10/20/17
Job No: 165400

Work Order ID 165400

Monday, August 21, 2017 3:21:22 PM

165400

Page 1

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Outboard LH
Start Date: 8/31/2017 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 9/7/2017 Req'd Qty: 7.00 ***7*** Customer:
Reference:

Approvals: Process Plan: uu Date: 17/8/22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ DAS 21 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	D								

100

2.92

100

HAAS CNC VERTICAL MACHINING #1

3.97

HAAS 1

MemoProgram Batch No. 500177

Double check by: _____

1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets

MILL AS PER DWG AND FOLIO FA815

FOLIO REV: _____

DWG REV: _____

DAS449-8917-10-21

105

0.00

105

0.00

Mill Conv

Memo

MILL KEYWAY AS PER DWG

DAS449-8917-10-21

Conventional Milling Machine

Work Order ID 165400

Monday, August 21, 2017 3:21:22 PM

165400

Page 2

Item ID: D3883-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Outboard LH

Start Date: 8/31/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 9/7/2017 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.07

Quality Control

DAS

44

9-89

17-10-21

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.14

Quality Control

DAS

08

9-89

Do 17-10-24

7

0

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.98

Hand Finishing

(7)

0

2017/10/24

256

Work Order ID 165400

Monday, August 21, 2017 3:21:22 PM

165400

Page 3

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard LH
 Start Date: 8/31/2017 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 9/7/2017 Req'd Qty: 7.00 ***7*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** M 138014. ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: 2:50 OVEN TEMPERATURE: 320 FINISH TIME: 3:00	0.00 0.50				7	0	17-10-24.	DAS 32 9-89 9-89
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.07				7			DAS 32 9-89 OCT 25 2017

Monday, August 21, 2017 3:21:22 PM

Page 4

Quality Control



Picklist Print

Monday, August 21, 2017 3:21:22 PM

Page 1

Work Order ID: 165400

165400

Parent Item: D3883-1

D3883-1

Parent Item Name: Saddle, Outboard LH

Start Date: 8/31/2017

Required Date: 9/7/2017

Start Qty: 7.00

Required Qty: 7.00

Comments:

IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No			100	Each	10.0000	1	7			
D6101-015									**				
Saddle Billet													

Location

MAT045

162154

Loc Qty

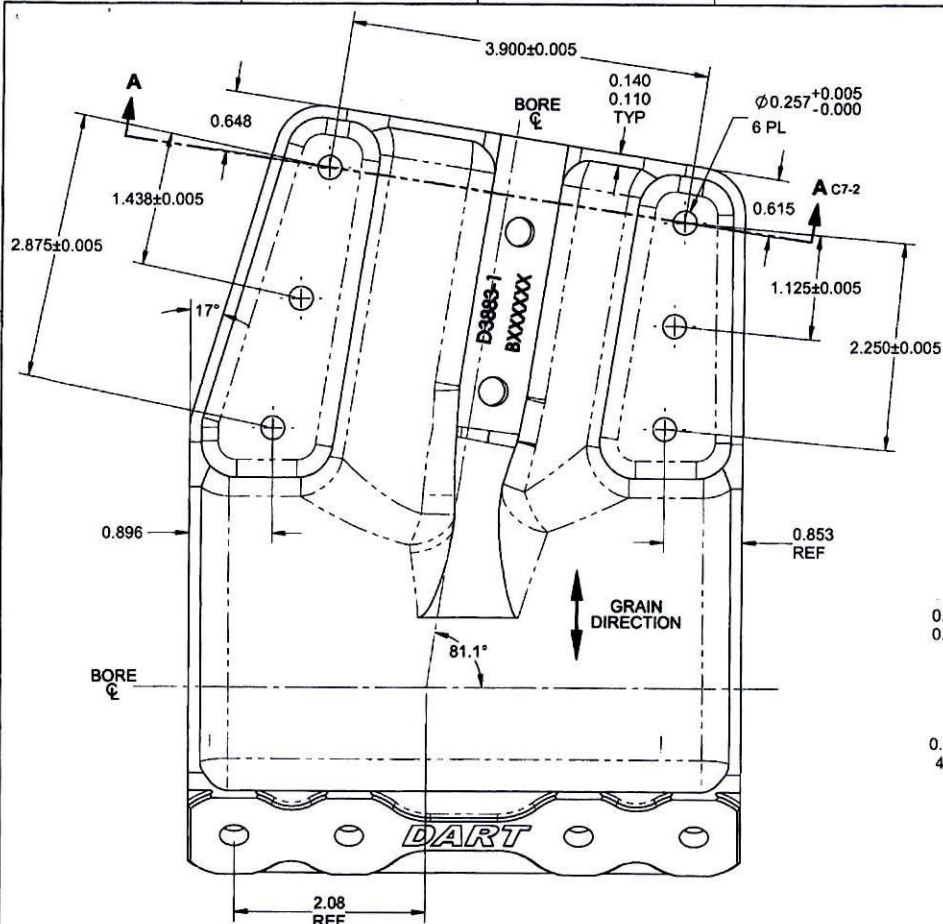
10

10

Loc Code

7

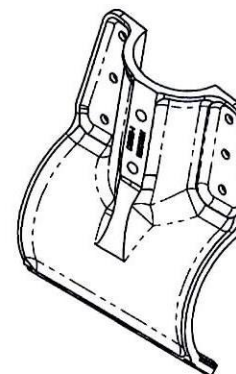
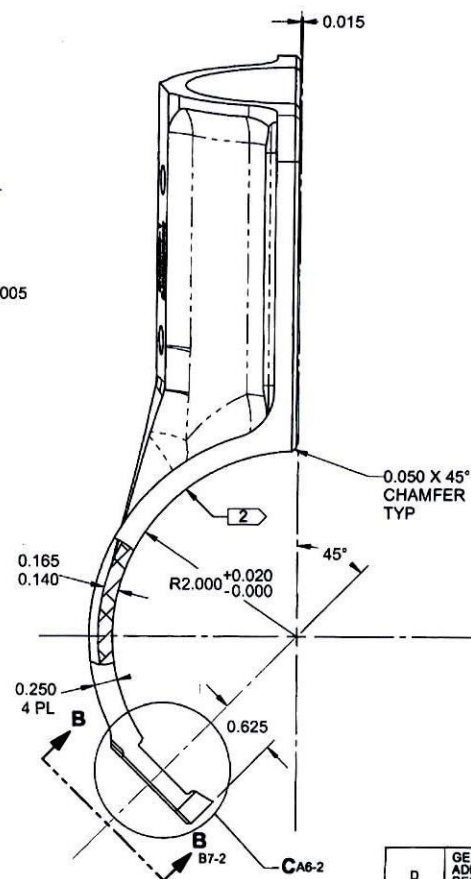
17/10/20 SBL01



D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REV.D.SLDPRT"

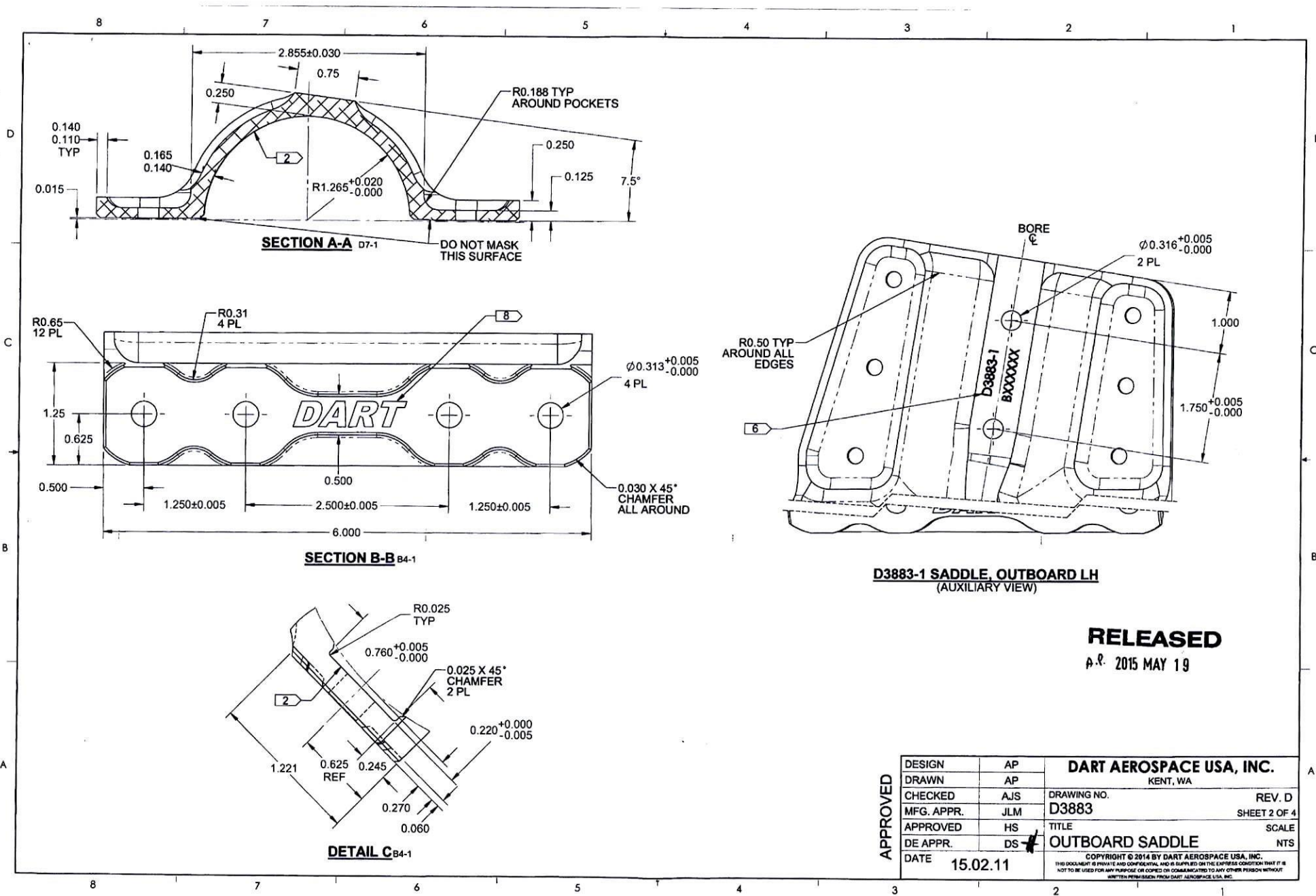


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165400
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2015 MAY 19
A.P. Ecn15-575

D	GENERAL REDRAW, ADDED D3883-2 ON SHEETS 3 & 4, ADDED NOTE 9 & REMOVED UNNECESSARY DIMS, REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1/2	AP	15.02.11
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015, ZN A7-1; ADD 0.648, ZN D7-1; ADD 0.615, ZN D6-1; ADD 0.125, ZN D7-2; ADD 0.060 & R0.031, ZN B5-2; 0.75 WAS 0.728, ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3883	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD SADDLE	NTS
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

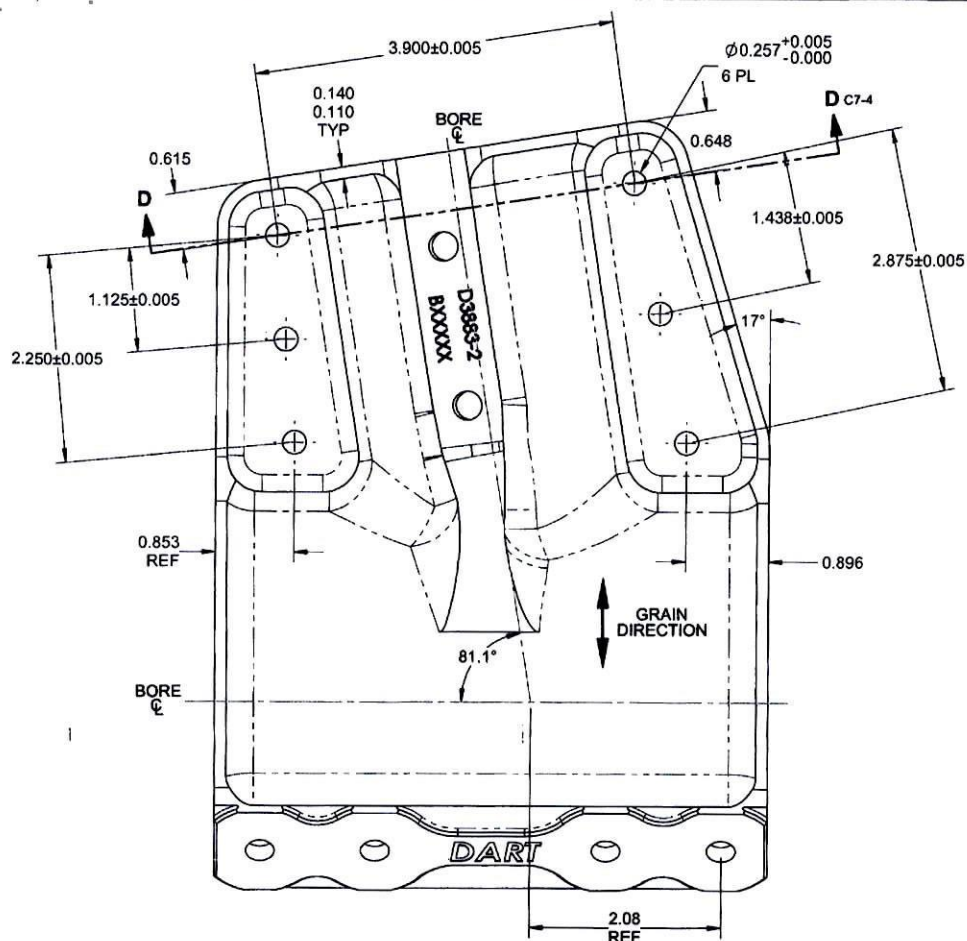
APPROVED



D3883-1 SADDLE, OUTBOARD LH
(AUXILIARY VIEW)

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P.R. 2015 MAY 19

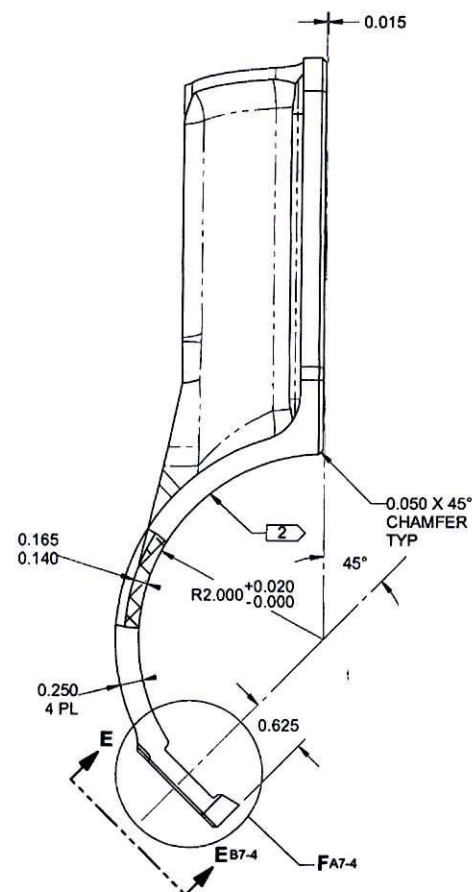
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	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 2 OF 4
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D3883-2 SADDLE, OUTBOARD RH

NOTES:

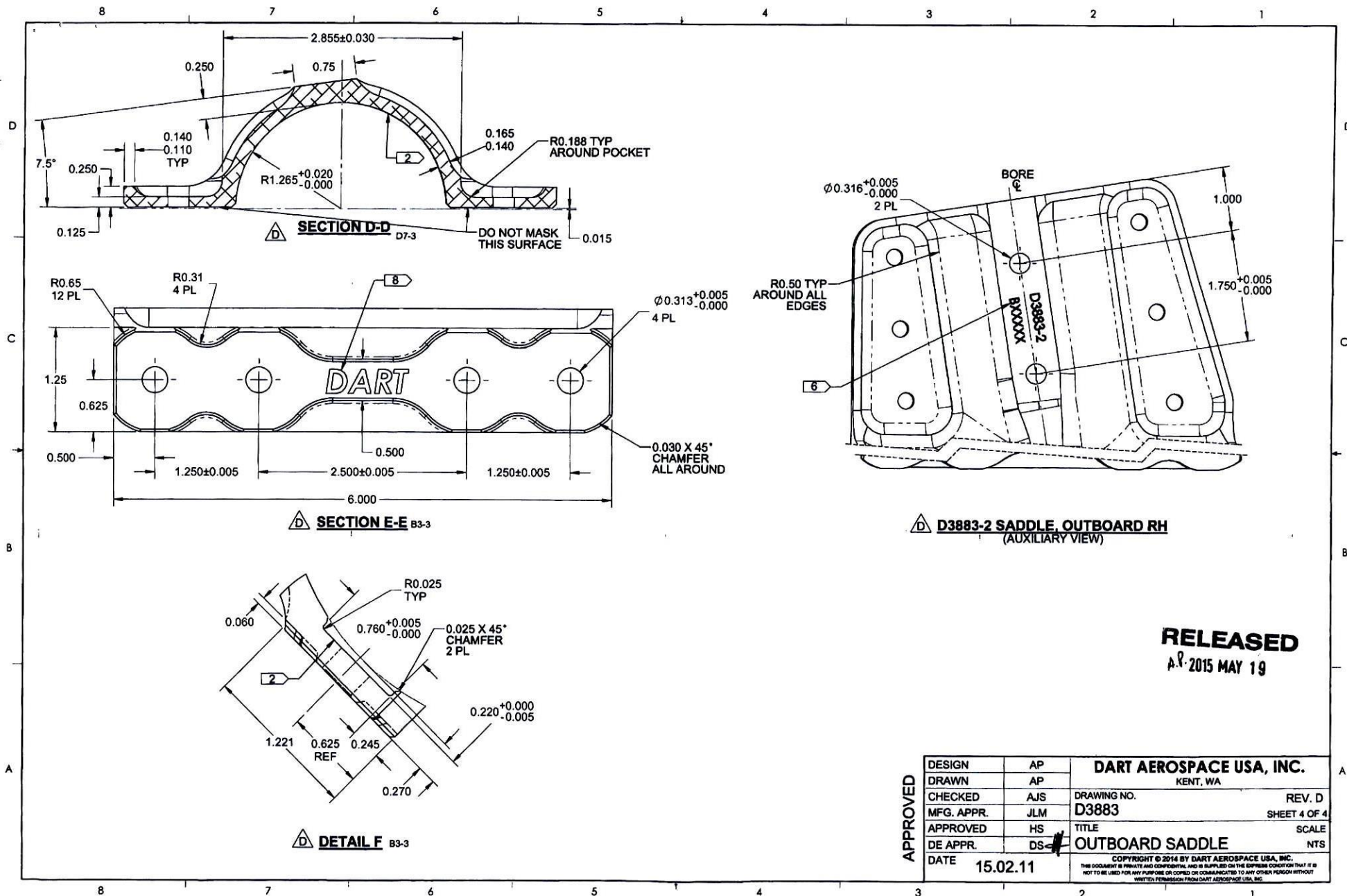
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REVD.SLDPRT"



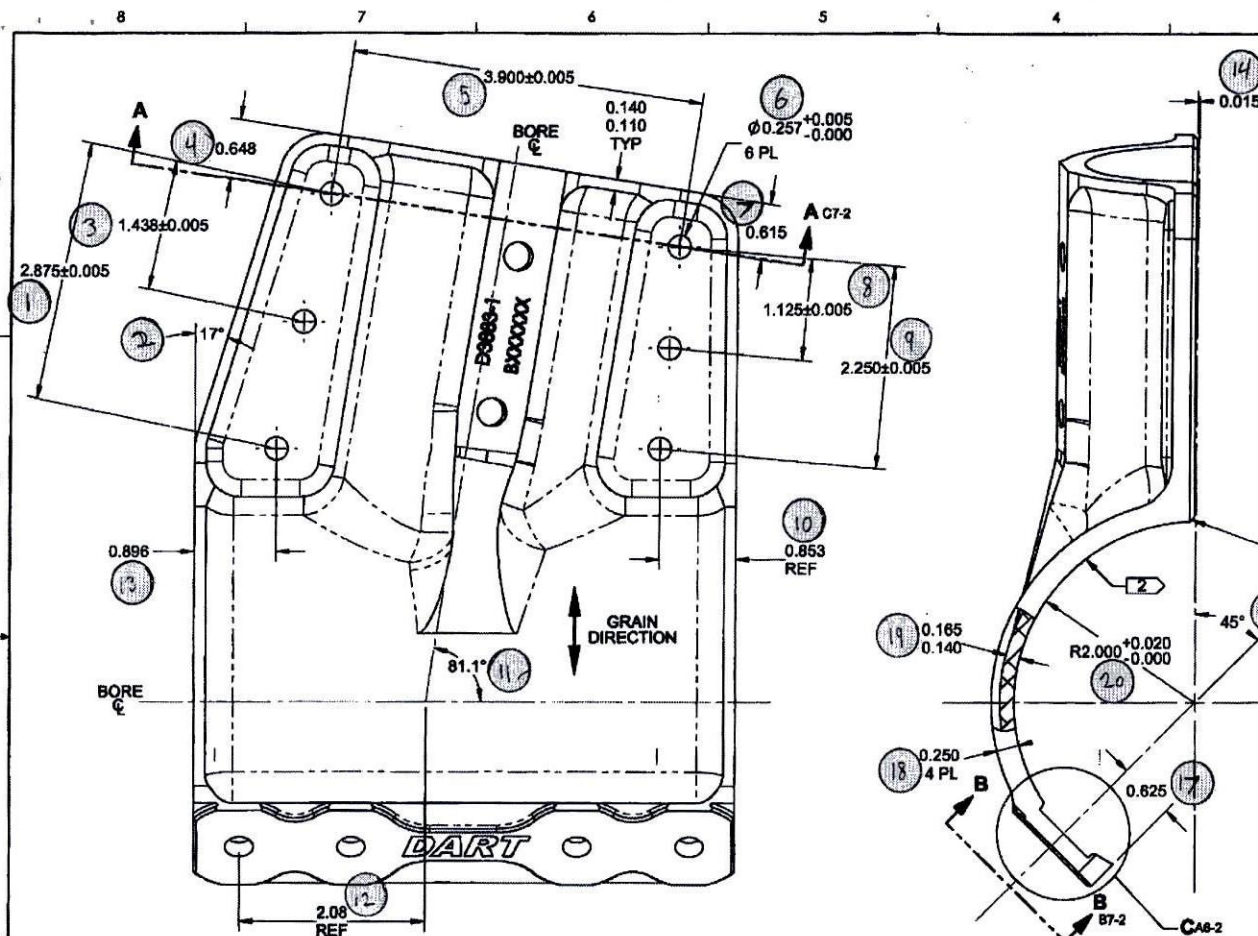
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D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D8101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REV.D.SLDPRT"

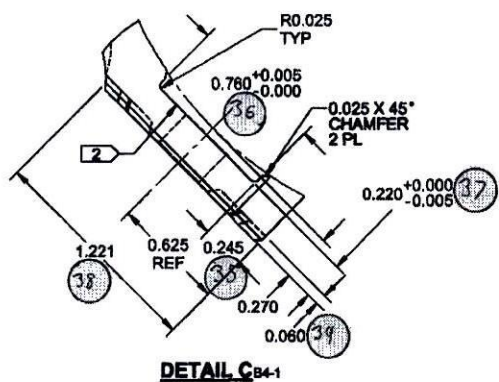
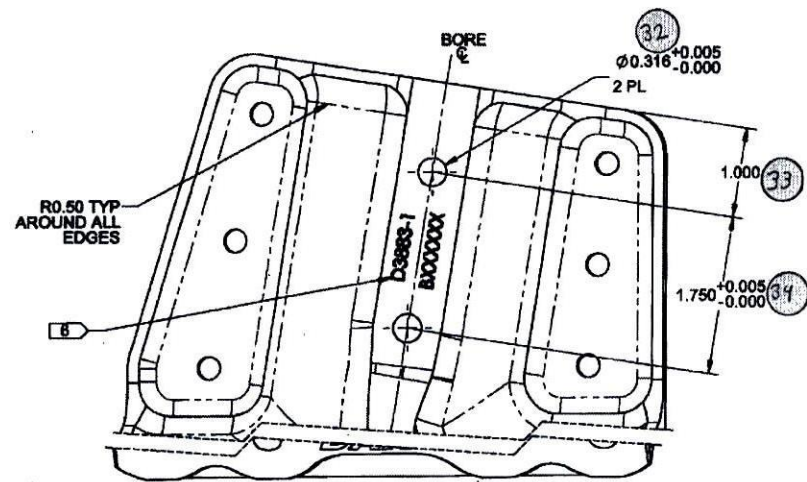
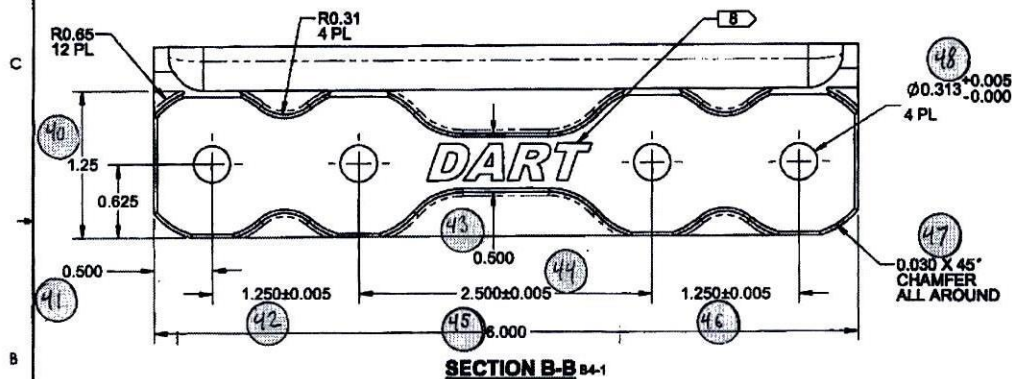
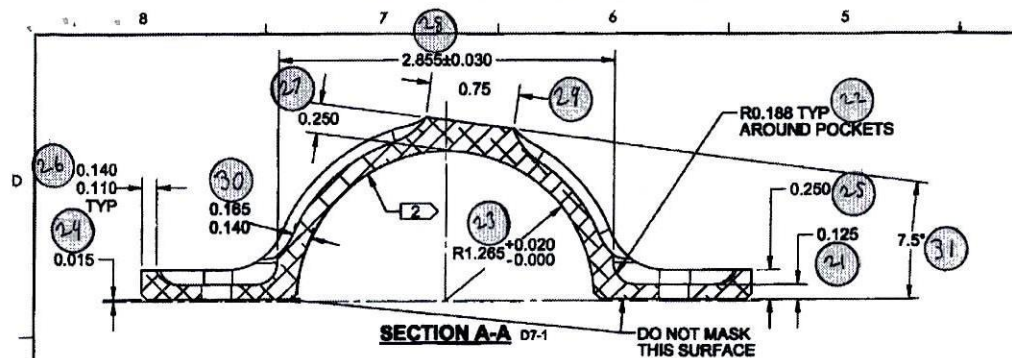
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D	GENERAL REDRAW, ADDED D3883-2 ON SHEETS 3 & 4, ADDED NOTE 9 & REMOVED UNNECESSARY DIMS, REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1-2	AP	15.02.11
C	ADD R1.205 (ZN D8-2)	RF	09.11.09
B	D8101-015, ZN A7-1; ADD 0.848, ZN D7-1; ADD 0.815, ZN D8-1; ADD 0.125, ZN D7-2; ADD 0.080 & R0.031, ZN B5-2; 0.75 WAS 0.728, ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3883 TITLE OUTBOARD SADDLE SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS FREELY AVAILABLE TO THE PUBLIC. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	
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DE APPR.	D8	REV. D SHEET 1 OF 4 DATE 15.02.11	



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DART AEROSPACE LTD		Work Order: 165400
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.646	.645	.645	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.145	.146	.147	.146		
K	0.240	0.260		.247	.248	.247	.246		
L	0.115	0.135		.126	.125	.125	.125		
M	0.140	0.165		.146	.147	.146	.146		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.258	.256	.255	.255		
P	0.110	0.140		.130	.130	.130	.130		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.856	2.856	2.856	2.856		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		.999	.999	.999	.999		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.498	.500	.500	.498		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.313	.313	.313	.313		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218	.218	.217	.217		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by:	Ek.
Date:	17-10-21

Audited by:	B.A.	DAC
Date:	17-10-24	CB

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order: 165400
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions			4	By	Date
				5	6	7			
A	2.870	2.880		2.875	2.875	2.875			
B	1.433	1.443		1.438	1.438	1.438			
C	0.638	0.658		.646	.646	.645			
D	3.895	3.905		3.900	3.900	3.900			
E	0.257	0.262		.257	.257	.257			
F	0.605	0.625		.615	.615	.615			
G	1.120	1.130		1.125	1.125	1.125			
H	2.245	2.255		2.250	2.250	2.250			
I	2.000	2.020		2.000	2.000	2.000			
J	0.140	0.165		.147	.148	.146			
K	0.240	0.260		.247	.248	.249			
L	0.115	0.135		.125	.125	.125			
M	0.140	0.165		.147	.146	.146			
N	0.720	0.780		.760	.760	.760			
O	0.240	0.260		.255	.256	.256			
P	0.110	0.140		.130	.130	.130			
Q	0.178	0.198		.188	.188	.188			
R	2.825	2.885		2.856	2.856	2.856			
S	0.316	0.321		.316	.316	.316			
T	0.990	1.010		.999	.998	.999			
U	1.745	1.755		1.750	1.750	1.750			
V	5.990	6.010		6.000	6.000	6.000			
W	1.245	1.255		1.250	1.250	1.250			
X	0.490	0.510		.500	.501	.500			
Y	1.220	1.280		1.250	1.250	1.250			
Z	2.495	2.505		2.500	2.500	2.500			
AA	0.313	0.318		.313	.313	.313			
AB	0.020	0.040		.030	.030	.030			
AC	0.760	0.765		.760	.760	.760			
AD	0.215	0.220		.217	.217	.217			
AE	1.265	1.285		1.265	1.265	1.265			
AF									
Accept/Reject									

Measured by:	FK.
Date:	17-10-22

Audited by:	A. DAS
Date:	17-10-24 08:09

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	



Traveller Change Request

Part#:

D3883-1

Job#:

165400

Name

Francis Kinouac.

Date

17-10-23

Workcenter

Mill conv

Operation #

105

Issue:

Quality ☐

Wrong Routing ☒

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested:

Integrate Mill conv in CNC op.

Name

Date

Workcenter

Operation #

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Name

Date

Workcenter

Operation #

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested:

